

ABSTRACT OF THE DISCLOSURE

Foundry plant is simplified in article-transfer steps, reduced in transfer distance between these steps, and does not use any overhead crane. Supply/storage area (10) for materials, molds, jigs and like articles is adjacent to Working area (11) for preparing a mold and a melt, and for pouring the melt and for disassembling a flask from the mold, thereby improving the plant in both worker's production efficiency and working area's production efficiency.

5 A multi-story warehouse (1) with a stacker crane (4, 4a) is in a central portion of the plant. A mold-making area (10) extends along one of opposite outer sides of the warehouse (1) to prepare a mold. A casting processing area (11) extends along the other outer side of the warehouse (1) thereby performing a metal melting, a melt

10 15 pouring, a mold cooling, a flaskdisassembling, and a casting surface treatment and cleaning operation.